

Work Order ID 111864

Thursday, January 23, 2014 4:12:07 PM

111864

Page 1

Item ID: D4634-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/29/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: 1-21-23 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4634	E

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

① SAD 14/01/27

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D4634-141

scotch-weld 1300L BTH m1279131- Locate and glue down Channel Assy, angles, brackets, and mounting pads
using 3M Plastic welder II.Batch # m127913Expiry Date 7/10/20142- Apply labels as per Dwg. and seal with 3M 3950 edge sealer BTH m124725① SAD 14/01/28

Work Order ID 111864

Thursday, January 23, 2014 4:12:07 PM

111864

Page 2

Item ID: D4634-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Replacement Panel Assembly
Start Date: 1/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/29/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00 SHF 14/1/28				1			
125 *125* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 SHF 14/1/28				1			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>med Pub</u> Memo	0.00 0.00				①	SAD	14/6/28	

Work Order ID 111864

Thursday, January 23, 2014 4:12:07 PM

111864

Page 3

Item ID: D4634-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Replacement Panel Assembly
Start Date: 1/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/29/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5 14-01-29

① 14-01-28

DQA: DAH Date: 14/2/11

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: OK Date: 14-2-10

Work Order update only ☐

Work Order: <u>111864</u> Part No. <u>D4634-141</u> NCR No. _____	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> </tr> </table> <div style="text-align: right;"> (Drawing) Engineering <input checked="" type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>												
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>												
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>												
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>												

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14/01/28	100	x 1	WAS found during assembly that the Labels D4732 -15 /-19 are in the wrong location on the Drawings. R1. Drawing is faulty.	RE	Acceptable Per Attachments Emer 1	RF	S 14/02/04	S 14/02/10
Doc/Data	X									
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

Thursday, January 23, 2014 4:12:11 PM

Page 1

Work Order ID: 111864

111864

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A New Issue 13/02/05 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 13/07/09 DL verf: DD IPP Rev. C Dwg Update
remove channels add Foam 13/12/23 DL IPP REV D 14/01/20 Dwg Update
DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D5021-1		Manufactured	No			100	Each	1.0000	1	1			
D5021-1									**				
Foam, Center Panel, Fwd													

Location Loc Qty Loc Code

prelim 1
111350 1

MS20426AD3-4		Purchased	No			100	Each	10,559.00	4	4			
MS20426AD3-4									**				
RIVET													

Location Loc Qty Loc Code

ST334 4000
m127432 4000
ST509 6559
125578 6559

MS20426AD4-6		Purchased	No			100	Each	3,086.000	2	2			
MS20426AD4-6									**				
Rivet													

Location Loc Qty Loc Code

GA 1582
m126474 1582
ST334 1504
124392 1504

3

SAD 13/01/27

SAD 14/01/27

SAD 14/01/27

2

Picklist Print

Thursday, January 23, 2014 4:12:11 PM

Page 2

Work Order ID: 111864

111864

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

MS21059L08

Purchased No

100 Each

1,112.000 2 2

MS21059L08

Nut

**

SAD 14/01/27

Location

Loc Qty

Loc Code

ST508

1112

125654

1112

2

D4634-1

Manufactured No

100 Each

0.0000 1 1

D4634-1

Fwd, Center Ceiling Panel

**

SAD 14/01/27

D4636-5

Manufactured No

100 Each

36.0000 1 1

D4636-5

Bracket

**

SAD 14/01/27

Location

Loc Qty

Loc Code

ST115

36

111230

36

1

D4647-5

Manufactured No

100 Each

6.0000 1 1

D4647-5

Doubler

**

SAD 14/01/27

Location

Loc Qty

Loc Code

ST116

6

111236

6

1

D4664-5

Manufactured No

100 Each

64.0000 6 6

D4664-5

Spacer

**

SAD 14/01/27

Location

Loc Qty

Loc Code

prelim

64

111711

64

6

Thursday, January 23, 2014 4:12:11 PM

Shop Packet Print

Page 2

Picklist Print

Thursday, January 23, 2014 4:12:11 PM

Page 3

Work Order ID: 111864

111864

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

D4712-1

Manufactured No

100

Each

10.0000

1

1

D4712-1

Bracket

**

SAD 14/01/27

Location

Loc Qty

Loc Code

prelim

2

110411

2

ST121

8

111162

8

D4732-15

Manufactured No

100

Each

20.0000

1

1

D4732-15

Label

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST122

20

111246

15

93220

5

D4732-19

Manufactured No

100

Each

20.0000

1

1

D4732-19

Label

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST122

20

111248

15

93356

5

MPNY-750S-9-C

Purchased No

100

Each

957.0000

8

8

MPNY-750S-9-C

Mounting Pad

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST390

957

124058

1

M127960

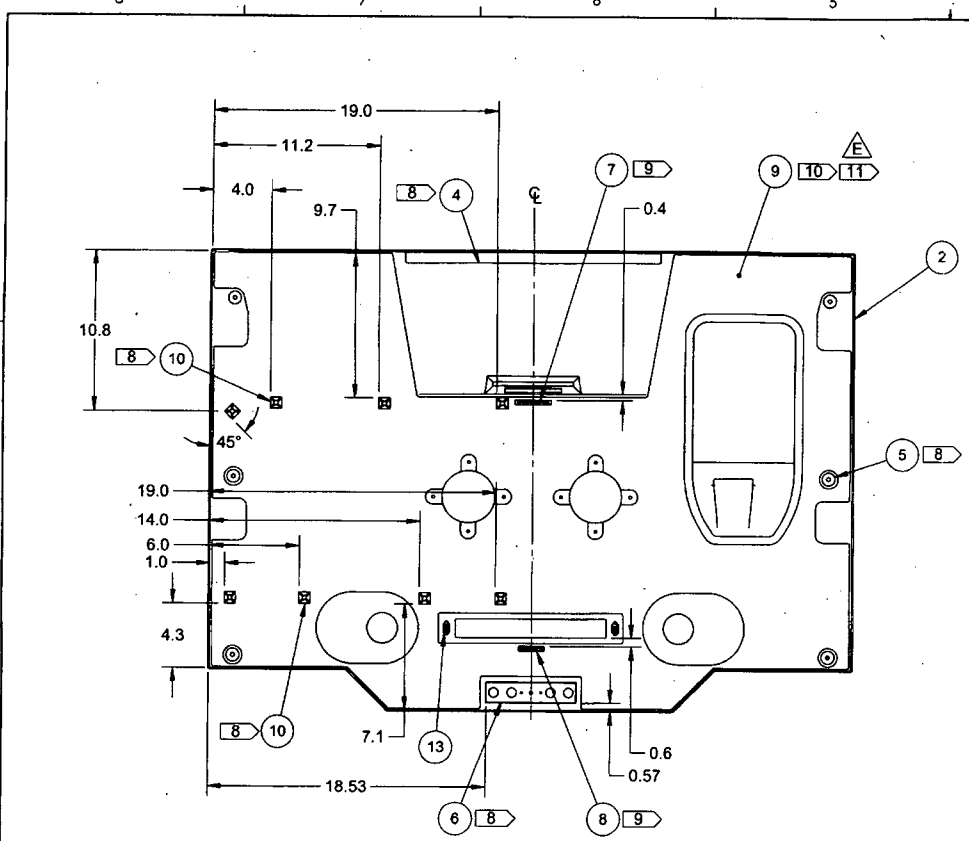
956

Thursday, January 23, 2014 4:12:11 PM

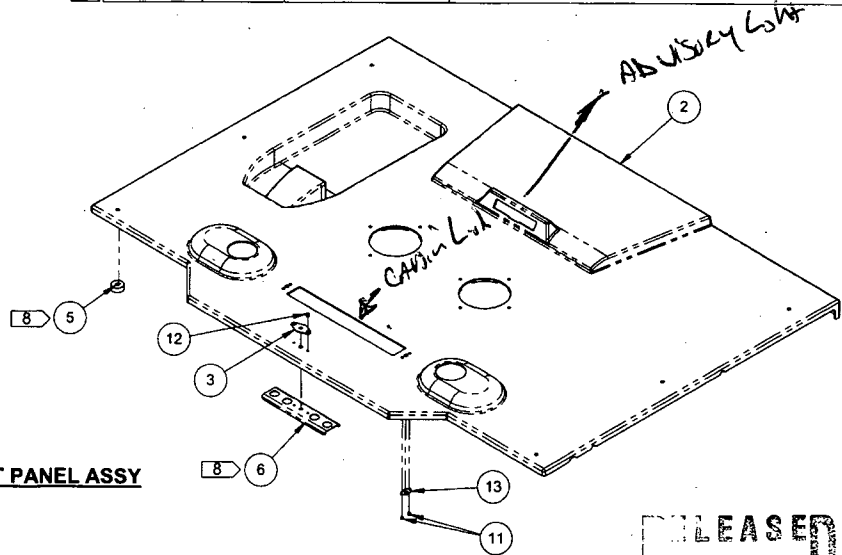
Shop Packet Print

Page 3

111964 R4401-23



ITEM NO.	QTY. -141	PART NUMBER	DESCRIPTION
1	X	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-1	FWD, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-5	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-19	LABEL
8	1	D4732-15	LABEL
9	1	D5021-1	FOAM, CENTER PANEL, FWD
10	8	MPNY-750S-9-C	MOUNTING PAD
11	4	MS20426AD3-(4)	RIVET
12	2	MS20426AD4-(6)	RIVET
13	2	MS21059L08	ANCHOR NUT



D4634-141 FWD, CENTER CEILING REPLACEMENT PANEL ASSY

RELEASED
2014-01-22

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4664-5, D4712-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
 - 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
 - 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-1 FOAM CORE TO INSIDE OF PANEL
 - 11) CENTER D5021-1 FOAM ON D4634-1

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4634	SHEET 7 OF 17
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	CENTER CEILING PANELS	NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Eric Downing

From: Roberto Fuentes
Sent: Tuesday, January 28, 2014 11:48 AM
To: Eric Downing; Harvey Siemens
Cc: Patrick Smith; Nigel Forbes; Mike Petsche
Subject: RE: D4634-141

Hi Eric,

Yes, you are correct the label items number need to be switch in each other. Therefore Advisory Light Fwd (D4732-15) should read item (7) and Cabin Light #1 (D4732-19) should be read item (8).

Use this e-mail attach to WO to correct this typo. This will corrected in the next revision of this drawing.

Thanks to let me know that.
Roberto

From: Eric Downing
Sent: January-28-14 9:06 AM
To: Roberto Fuentes
Cc: Patrick Smith; Nigel Forbes; Mike Petsche
Subject: D4634-141
Importance: High

Good morning Roberto

Steven Droiu is assembling a D4634-141 fwd center panel for the 139 and he has noticed that the in your drawings you have the labels (D4732-15/-19) switched.

Where you have the D4732-15 the D4732-19 should be installed their and so on.

Please double check that out ASAP cause I do believe that the set that was just sent out on Friday is the same so it is wrong!

I can write up a hand change on the back of the work order for this one but a NCR will need to be raised for this

Eric Downing
QC Coordinator
T: 1-613-632-5200 ext 223
C: 1-613-363-9375
F: 1-613-632-5246
www.dartaero.com
Edowning@Dartaero.com

